

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010934**Date Inspected:** 08-Dec-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Du Zhi Qun, Liu Zhong An**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

BAY 11 TOWER SPARE STRUT

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% and random Visual Testing (VT) of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT reports for this date. The members are identified as Tower Components. The weld designations reviewed are as follows.

SD1-A6002-10 GREEN TAG NO. 9314

SD1-A6002-12 GREEN TAG NO. 9315

ERECTION ASSEMBLY JETTY WEST TOWER LIFT 1 SKIN PLATE WITH BASE PLATE

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% and random Visual Testing (VT) of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT reports for this date. The members are identified as Tower Components. The weld designations reviewed are as follows.

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WSD1-A423B/H-84, 95, 99, 106, 108, 109, 63, 64, 73, 74, 75, 76, 135, 119, 123

This Quality Assurance (QA) Inspector observed the following work in progress:

Bay 10

SPARE STRUT

SMAW welding of weld joint 61A located on ED1-STSA3-2-89M-1.

Welder is identified as 040582. ZPMC CWI is identified as Mr. Du Zhi Qun.

The welding variables recorded by QC appeared to comply with WPS-B-T-3212-Tc-U5b-1.

SMAW welding of weld joint 24A located on ED1-STSA3-2-109M-1.

Welder is identified as 052493. ZPMC CWI is identified as Mr. Du Zhi Qun.

The welding variables recorded by QC appeared to comply with WPS-B-T-2212-Tc-U5b.

INTERIOR SPLICE PLATE

FCAW welding of weld joint 1A located on NSD1-SPSA4-18.

Welder is identified as 053870. ZPMC QC is identified as Mr. Sun Tian Liang.

The welding variables recorded by QC appeared to comply with WPS-B-T-2231-Tc-U5-F.

NORTH TOWER LIFT 4

FCAW welding of weld joint 42 located on NSTL4-3K/L.

Welder is identified as 040338. ZPMC QC is identified as Mr. Deng Zhi Bing.

The welding variables recorded by QC appeared to comply with WPS-B-T-2333-Tc-P4-F.

SOUTH TOWER LIFT 4

FCAW welding of weld joint 87 located on SSTL4-1H/L.

Welder is identified as 040343. ZPMC CWI is identified as Mr. Wang Chuan Qing.

The welding variables recorded by QC appeared to comply with WPS-B-T-4331-Tc-P4-F.

BAY 11

CORNER SPLICE ASSEMBLY

FCAW welding of weld joint 2A located on ESD1-SPSA4-30.

Welder is identified as 040713. ZPMC QC is identified as Mr. Li Jun.

The welding variables recorded by QC appeared to comply with WPS-B-T-2232-B-U5-F.

FCAW welding of weld joint 2A located on WSD1-SPSA4-1.

Welder is identified as 049220. ZPMC QC is identified as Mr. Li Jun.

The welding variables recorded by QC appeared to comply with WPS-B-T-2232-B-U5-F.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Umesh	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
